

# Work Order ID 80286

February-16-12 10:27:36 AM

**\*80286\***

Page 1

Item ID: D3391-025

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Stop

**\*NS2\***

Item Name: Aft Tube Assembly

Start Date: 16/02/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 01/03/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan: M.L.J Date: 12/02/12 Tooling:

Date:

Run Start

**\*NR1\***

QC: Date: SPC (Y/N):

Date:

Stop

**\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3391	I								

100

0.00

**\*100\***

MORI SEIKI CNC LATHE LARGE

Mori Seiki

Memo

0.00

Mori Seiki CNC Lathe Large

Turn as per Folio FA599

Rev: AA & Dwg D3391 Rev: 1

\*\*\*scribe batch # on fwd end at 90 degree\*\*\*

*BA/SC 12/03/12*

110

0.00

**\*110\***

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

*BA/SC 12/03/12*

111

0.00

**\*111\***

QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

\*\*\*INSPECT INSIDE BORE\*\*\*

*BA 12.3.3*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 80286

February-16-12 10:27:36 AM

**\*80286\***

Page 2

Item ID: D3391-025 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Aft Tube Assembly  
 Start Date: 16/02/2012 Start Qty: 1.00 **\*1\*** Cust Item ID:  
 Required Date: 01/03/2012 Req'd Qty: 1.00 **\*1\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	HAAS CNC VERTICAL MACHINING #1	0.00							
<b>*120*</b>									
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	1-Machine as per Folio FA 599 Rev: <u>1/1</u> & Dwg D3391 Rev: <u>1</u> 2-Deburr								
130	QC2- Inspect parts off machine FAI/FAIB	0.00							
<b>*130*</b>									
QC	Memo	0.00							
Quality Control									
140	QC8- Inspect parts - second check	0.00							
<b>*140*</b>									
QC	Memo	0.00							
Quality Control	***INSPECT INSIDE BORE***								

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**\*80286\***

February-16-12 10:27:36 AM

\*N900040100\*

**Cust Item ID:**  
**Customer:**

Run	Start	*NR1*
	Stop	*NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150		0.00							
*150*	Skidtubes								
Skidtubes	Memo	0.00							
Skidtubes	1-Drill ( PILOT HOLE) aft cap holes per Dwg D3391 using DT8803				- DC 12/03/07				
160		0.00							
*160*	BENDING MACHINE - SKIDTUBES								
CNC Bend I	Memo	0.00							
CNC Delta 100 Bender	Form as per Dwg D3391 Using Bend Prog 3391025				DC 12/03/07				
170		0.00							
*170*	QC5- Inspect part completeness to step on W/O								
QC	Memo	0.00							
Quality Control					4.33"				DD 12-3-7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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**NOTE:** Date & initial all entries

**Work Order ID 80286****\*80286\***

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Item ID: D3391-025

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Aft Tube Assembly

Start Date: 16/02/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 01/03/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start **\*NR1\***

QC: Date: SPC (Y/N): Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

180

0.00

**\*180\***

Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-Open Aft cap pilot hole to .208" as per Dwg D3391

2-Drill float bag holes using DT8809 as per Dwg D3391(Holes marked "A" Only.

3-Drill wearplate holes as per Dwg D3391 using DT8878(Mid Tube) & DT8217  
Wearplate Jig.

\*\*\*\*\*Do Not Open To Finished Size\*\*\*\*\*

4-Drill Wearshoe holes as per DWG D3391 using DT8939 locating from 2  
previously drilled aft wearplate holes.

5-Open wearplate holes to 0.250" and c'bore as per dwg D3391

6-Open up all wearshoe , wearplate to 0.297"and float bag holes to 0.328" as per  
Dwg D3391.

7-Deburr

OK 12/03/08

OK 12/03/13

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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# Work Order ID 80286

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Item ID: D3391-025 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Aft Tube Assembly  
 Start Date: 16/02/2012 Start Qty: 1.00 \*1\* Cust Item ID:  
 Required Date: 01/03/2012 Req'd Qty: 1.00 \*1\* Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 *190* QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00 0.00		8/26/13					
200 *200* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1  Memo	0.00 0.00							
210 *210* QC Quality Control	QC3- Inspect Part Finish QC7 Memo	0.00 0.00							

① DVB, 12-3-13  
/ DC 12/03/13

① ——— SAA 12-03-15  
PTO ⇒

**Dart Aerospace Ltd**

W/O: 80286		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
12-03-18	218	change Qc3- to Qc7  Already done JJ						

Part No: D3391-025 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Work Order ID: 80286

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Item ID: D3391-025

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Aft Tube Assembly

Start Date: 16/02/2012 Start Qty: 1.00

\*1\*

Cust Item ID:

Required Date: 01/03/2012 Req'd Qty: 1.00

\*1\*

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220		0.00							
*220*	Skidtubes								
Skidtubes	Memo	0.00							
Skidtubes	Instal spacers as per dwg D3391 A/R Magnabond 6398 Batch: 120666 exp. date: 13/1/30 cure time 12hrs as per QSI0015								
									DR 12/03/15
230	QC5- Inspect part completeness to step on W/O	0.00							
*230*									
QC	Memo	0.00							
Quality Control									
235	Pressure Wash per QSI005 4.3	0.00							
*235*									
HandFinish	Memo	0.00							
Hand Finishing	AND REALODINE AS PER PAR09-043								

1X Ø m 12/03/17

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 80286

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Item ID: D3391-025 Accept \*N900040100\* Setup Start \*NS1\*  
Revision ID: Stop \*NS2\*  
Item Name: Aft Tube Assembly  
Start Date: 16/02/2012 Start Qty: 1.00 \*1\* Cust Item ID:  
Required Date: 01/03/2012 Req'd Qty: 1.00 \*1\* Customer:  
Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start \*NR1\*  
QC: Date: SPC (Y/N): Date: Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
240	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
*240*									
Powdercoat	Memo	0.00							
Powder Coating	START TIME: 10:35 OVEN TEMPERATURE: 320° FINISH TIME: 10:55								
250	QC3- Inspect Part Finish	0.00							
*250*									
QC	Memo	0.00							
Quality Control									
260	HandFinishing	0.00							
*260*									
HandFinish	Memo	0.00							
Hand Finishing	1-Install inserts as per Dwg D3391 2-Install Aft Cap as per Dwg D3391 A/R Sikaflex-241/-291 11/12/03/18 Sikaflex expiry date: 12/08								
	3- INSTALL WEARPLATES AS PER DWG								

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / *Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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# Work Order ID 80286

February-16-12 10:27:36 AM

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Item ID: D3391-025

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Aft Tube Assembly

Start Date: 16/02/2012 Start Qty: 1.00

\*1\*

Cust Item ID:

Required Date: 01/03/2012 Req'd Qty: 1.00

\*1\*

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

270

QC5- Inspect part completeness to step on W/O

0.00

\*270\*

QC

Memo

0.00

Quality Control

280

Identify as per dwg & Stock Location: W/O

0.00

\*280\*

Packaging

Memo

0.00

Packaging

290

QC21- Final Inspection - Work Order Release

0.00

\*290\*

QC

Memo

0.00

Quality Control

12-04-3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

February-16-12 10:27:40 AM

Page 1

Work Order ID: 80286

\*80286\*

Parent Item: D3391-025

\*D3391-025\*

Parent Item Name: Aft Tube Assembly

Start Date: 16/02/2012

Required Date: 01/03/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev B 06-02-07 ECN773 dwg rev. D EC  
 IPP Rev:C 06-03-28 Update Manuf. Instructions JLM  
 IPP rev D 07.03.20 revF dwg EC  
 IPP rev E 07.11.07 rev G dwg ecn 1053p EC verified by: DD  
 IPP Rev:F 07-11-13 ECN 1056 DD verified by: EC  
 IPP Rev:G 08-09-10 revH as per dwg DD verified by:EC IPP Rev:H  
 11.11.14 AS PER REV.I DD verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D4095-047

Manufactured No

260

Each

16.0000

1

1

\*D4095-047\*

Wearpad Assembly

\*\*

1380703 (x1) ML 12/03/25

Location

Loc Qty

Loc Code

FP001

4

77435

4

FP002

12

78325

12

D4095-049

Manufactured No

260

Each

11.0000

1

1

\*D4095-049\*

Wearpad Assembly

\*\*

1380704 (x1) ML 12/03/25

Location

Loc Qty

Loc Code

FP002

11

76538

4

77436

7

D6014-090

Manufactured No

100

Each

0.0000

1

1

\*D6014-090\*

ALUMINUM EXTRUSION

\*\*

77332 x1 56 12/03/02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Page 2

Work Order ID: 80286

\*80286\*

Parent Item: D3391-025

\*D3391-025\*

Parent Item Name: Aft Tube Assembly

Start Date: 16/02/2012

Required Date: 01/03/2012

Start Qty: 1.00

Required Qty: 1.00

D3670-4-200

Manufactured No

230

Each

99.0000

4

4

\*D3670-4-200\*

SPACER

\*\*

OK 12/03/15

Location

B80360

Loc Qty

Loc Code

(4)

LG001

99

72851

7

77500

32

78606

60

D2646

Manufactured No

270

Each

106.0000

1

1

\*D2646\*

Aft Cap

\*\*

B79500 (x1) MU 12/03/28

Location

Loc Qty

Loc Code

FP002

106

62678

5

68280

5

70945

1

71070

2

73294

1

73825

42

78018

50

D3672-1

Manufactured No

270

Each

924.0000

2

2

\*D3672-1\*

Phenolic Washer

\*\*

MU 12/03/28

Location

Loc Qty

Loc Code

FP001

288

66821

288

ST060

636

72229

136

76277

500

x2

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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February-16-12 10:27:40 AM

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Work Order ID: 80286

\*80286\*

Parent Item: D3391-025

\*D3391-025\*

Parent Item Name: Aft Tube Assembly

Start Date: 16/02/2012

Required Date: 01/03/2012

Start Qty: 1.00

Required Qty: 1.00

ALS4-1032-130

Purchased

No

260

Each

2,115.000

14

14

\*AI S4-1032-130\* ✕

\*\*

M120181 (X14) MU 12/02/28

Insert

ALS4-1032-130

Location

Loc Qty

Loc Code

ST280

1116

119084

116

120671

1000

ST281

999

119632

19

120410

980

ALS4-1032-225

Purchased

No

270

Each

1,382.000

8

8

\*AI S4-1032-225\*

\*\*

MU 12/02/28

Insert

Location

Loc Qty

Loc Code

ST281

1031

108696

146

110768

62

118386

55

118966

68

120671

700

ST282

351

120410

200

120451

151

X8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 80286

\*80286\*

Parent Item: D3391-025

\*D3391-025\*

Parent Item Name: Aft Tube Assembly

Start Date: 16/02/2012

Required Date: 01/03/2012

Start Qty: 1.00

Required Qty: 1.00

AN3C4A

Purchased

No

270

Each

3,439.000

6

6

\*AN3C4A\*

BOLT

\*\*

ju

12/03/28

## Location

## Loc Qty

## Loc Code

ST350

3439

117313

2

117688

5

117872

10

118112

16

118451

2

119749

10

120187

2000

120423

394

120521

1000

X6

AN3C5A

Purchased

No

270

Each

1,038.000

4

4

\*AN3C5A\*

Bolt

\*\*

ju

12/03/28

## Location

## Loc Qty

## Loc Code

FP001

7

115835

7

ST350

1031

116419

28

117343

13

117764

7

117872

2

119127

24

119749

27

120423

930

X1

AN960C10L

NAS1149C0332

Purchased

No

270

Each

0.0000

10

10

\*AN960C10I \*

washer

\*\*

11/20/642

X10

ju

12/03/20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 80286
<b>Description:</b> Float Skidtube (412)		<b>Part Number:</b> D3391-3
<b>Inspection Dwg:</b> D3391	<b>Rev:</b> H I	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
<b>Lathe Section</b>						
14.000	+/-0.010	14.002	✓		Caliper	BA 06
3.500	+/-0.010	3.495	✓			"
88.93	+/-0.030	88.93	✓		Tape	BA 09
Ø3.200	+/-0.010	3.207	✓			BA 06
88.93	+/-0.030	88.93	✓		Tape	BA 09
Ø3.750	+/-0.010	3.746	✓			BA 06
30° x 160° chamfer	+/-0.010	✓	✓			

<b>Measured by:</b> HA/BC	<b>Date:</b> 12/03/07
<b>Audited by:</b> Re	<b>Date:</b> 2-3-3

<b>HAAS Section</b>						
1.526	+0.000/-0.030	1.516	✓		Re-15	
7.500	+/-0.010	7.500	✓			
27.750	+/-0.010	27.750	✓			
31.750	+/-0.010	31.750	✓			
35.250	+/-0.010	35.250	✓			
3.300	+/-0.010	3.302	✓			
0.200	+/-0.010	.200	✓			
3.520	+/-0.010	3.525	✓			
0.687	+0.010/-0.000	.687	✓			
R0.062	+/-0.010	2.062	✓			
Ø0.484	+0.005/-0.001	.487	✓			

<b>Measured by:</b> Re	<b>Date:</b> 12-3-3
<b>Audited by:</b> HA	<b>Date:</b> 12/03/07

Rev	Date	Change	Revised by	Approved
A	06.04.24	New Issue P/O D3391-015/-025	KJ/JLM	
B	06.06.19	Dwg revision update	KJ/JLM	
C	07.04.20	Ø0.208 dimension removed	KJ/JLM	
D	07.09.06	0.400 dimension removed	KJ/JLM	
E	07.11.23	Dwg Rev. updated	KJ/JLM	
F	09.04.27	Dimensions updated per Rev H and NCR09-028	KJ/JLM	
G	09.11.16	Dimension 0.200 removed	KJ	
H	11.06.21	Dimension 44.995 removed	KJ	

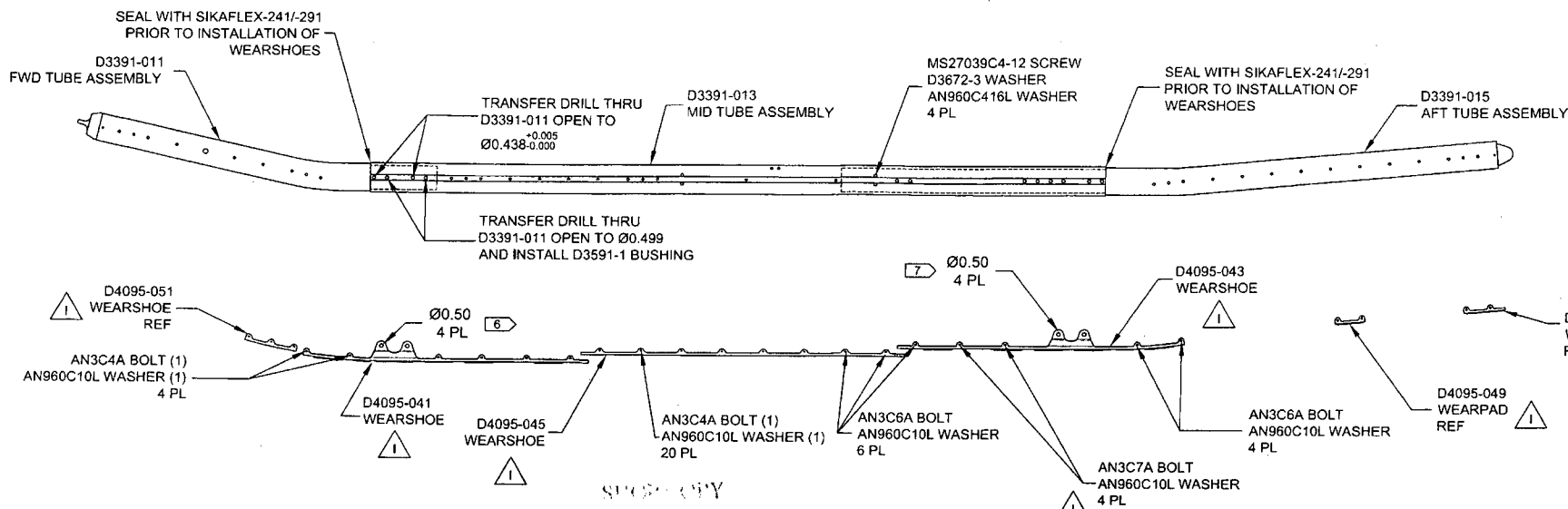
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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NOTE: Date & initial all entries



**D3391-041 FLOAT SKIDTUBE ASSEMBLY PARTS LIST**

QTY	PART NUMBER	DESCRIPTION
X	D3391-041	FLOAT SKIDTUBE ASSEMBLY
1	D3391-011	FWD TUBE ASSEMBLY
1	D3391-013	MID TUBE ASSEMBLY
1	D3391-015	AFT TUBE ASSEMBLY
2	D3591-1	BUSHING
4	D3672-3	WASHER
1	D4095-041	WEARSHOE
1	D4095-043	WEARSHOE
1	D4095-045	WEARSHOE
1	D4095-047	WEARSHOE
1	D4095-049	WEARPAD
1	D4095-051	WEARSHOE
24	AN3C4A	BOLT
10	AN3C6A	BOLT
4	AN3C7A	BOLT
38	AN960C10L	WASHER
4	MS27039C4-12	SCREW
4	AN960C416L	WASHER

UNCONTROLLED COPY  
SUBJECT TO CHANGE  
WITH NO EFFECT  
WORK CENTER  
NO. 80286 M.C.J  
12/02/16

**RELEASED**  
2011-11-04  
ECN# 11-662

**GENERAL NOTES**

- FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON"  
AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 SIZE HOLES  
FOR WEARSHOE INSERTS. C-BORE AS NOTED AND INSTALL INSERTS EXCEPT  
WHERE INDICATED.
- FIT D4095-041 TO SKIDTUBE WITH D2571 AND D2572 SADDLES INSTALLED WITH  
APPROPRIATE HARDWARE AND SPACERS IN FORWARD AND AFT HOLES AND  
TRANSFER DRILL Ø0.50 HOLES FROM SADDLE TO D4095-041
- FIT D4095-043 TO SKIDTUBE WITH D2571 AND D2572 SADDLES INSTALLED WITH  
THE APPROPRIATE HARDWARE AND SPACERS IN FORWARD AND AFT HOLES AND  
TRANSFER DRILL Ø0.50 HOLES FROM SADDLE TO D4095-043

I	REMOVE GASKETS AND REPLACE ALL WEARSHOES; PARTS LIST UPDATE, ZN A8-1, ZN A8-2, ZN A6-4, ZN B6-8; LPS-3 COATING REMOVED FROM NOTE 2, ZN A3-1, ZN A3-2, REMOVED INSERT AELS-1032-130, ZN B6-4, B2-4, C7-8, C3-8; REMOVED HOLES, ZN D6-4 ZN D2-4, ZN D7-8, ZN D3-8	XDF	11.10.13
H	DRAWING UPDATED TO CURRENT STANDARDS. SHT 1 PL ADDED D3591-1 BUSHING, ZN C6 Ø0.438 DIM WAS 4 PL. ADDED Ø0.499 DIM AND D3591-1 BUSHING. SHT 2 PL ADDED D3591-1 BUSHING, ZN C6 Ø0.438 DIM WAS 4 PL. ADDED Ø0.499 DIM AND D3591-1 BUSHING. (FOR FURTHER INFO SEE DSI 9364 & NCR 08-074)	AJS	08.08.20
G	REPLACE NAS INSERTS W/ AELS INSERTS SWITCH TO D3670-XXXX SPACERS FOR INSTALLING FLOAT BAGS, DWG REORGANIZED FOR CLARITY	DC	07.07.31
F	ADD SS WEARSHOE, GASKET REMOVE FWD SADDLE HOLE -011/-021	PH	07.01.18
E	CHANGE TOLERANCE, EASE MANUFACTURE	PH	06.04.25
D	UPDATE TOLERANCE, CHANGE HOLE SIZE	PH	06.01.23
C	LENGTHEN AFT EXTENSION	PH	05.09.27
B	DRAWING UPDATES	PH	05.06.10
A	NEW ISSUE	PH	05.02.07
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	<b>DART AEROSPACE USA, INC</b>	
DRAWN	XDF	KENT, WA	
CHECKED		DRAWING NO.	REV. 1
MFG. APPR.		D3391	SHEET 1 OF 8
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DE APPR.		412 FLOAT SKIDTUBE	NTS
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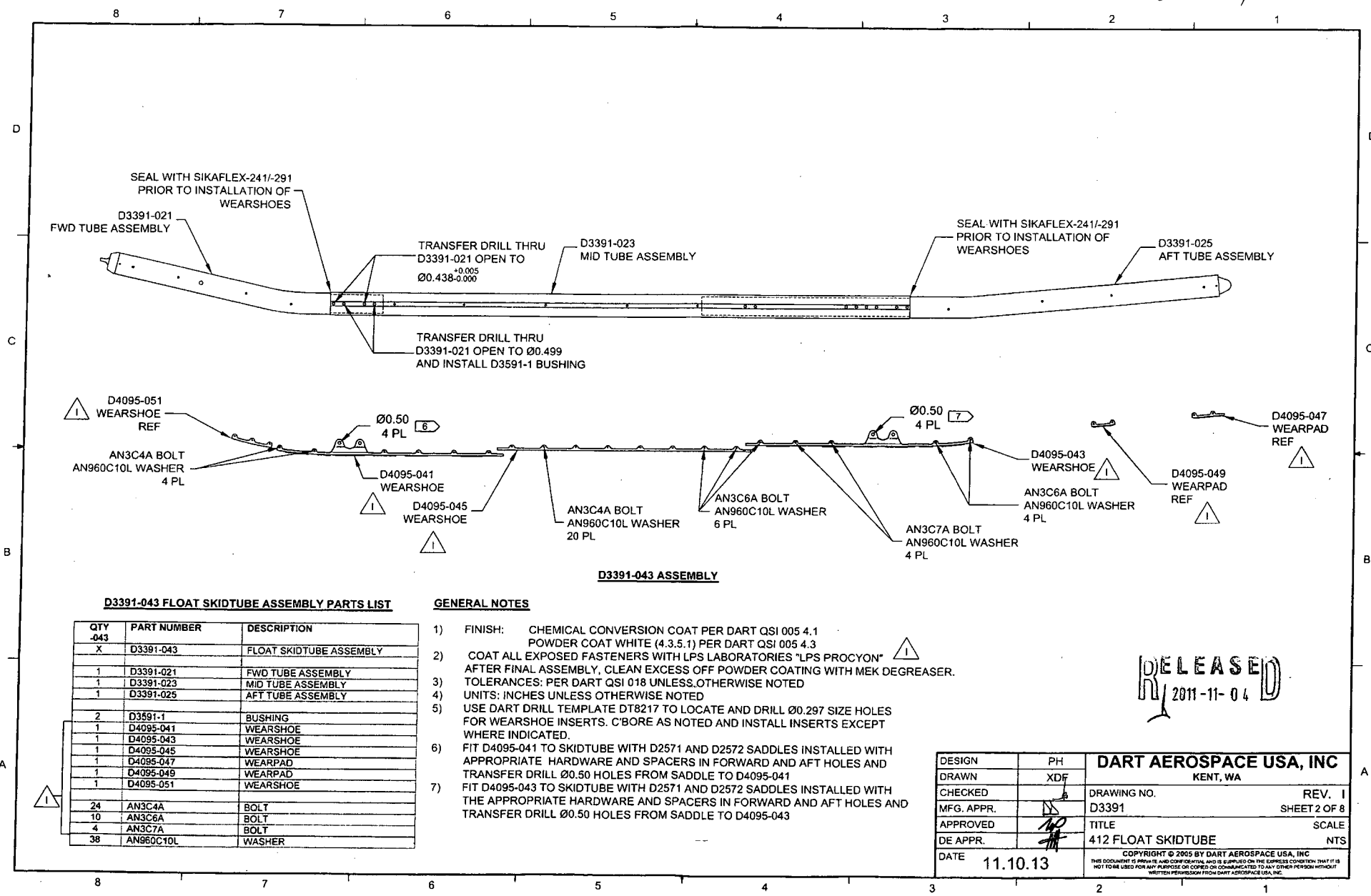
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

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**D3391-043 ASSEMBLY**

**D3391-043 FLOAT SKIDTUBE ASSEMBLY PARTS LIST**

QTY -043	PART NUMBER	DESCRIPTION
X	D3391-043	FLOAT SKIDTUBE ASSEMBLY
1	D3391-021	FWD TUBE ASSEMBLY
1	D3391-023	MID TUBE ASSEMBLY
1	D3391-025	AFT TUBE ASSEMBLY
2	D3591-1	BUSHING
1	D4095-041	WEARSHOE
1	D4095-043	WEARSHOE
1	D4095-045	WEARSHOE
1	D4095-047	WEARSHOE
1	D4095-049	WEARPAD
1	D4095-051	WEARSHOE
24	AN3C4A	BOLT
10	AN3C6A	BOLT
4	AN3C7A	BOLT
38	AN960C10L	WASHER

**GENERAL NOTES**

- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON"
- 3) AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 SIZE HOLES FOR WEARSHOE INSERTS. C'BORE AS NOTED AND INSTALL INSERTS EXCEPT WHERE INDICATED.
- 7) FIT D4095-041 TO SKIDTUBE WITH D2571 AND D2572 SADDLES INSTALLED WITH APPROPRIATE HARDWARE AND SPACERS IN FORWARD AND AFT HOLES AND TRANSFER DRILL Ø0.50 HOLES FROM SADDLE TO D4095-041
- 8) FIT D4095-043 TO SKIDTUBE WITH D2571 AND D2572 SADDLES INSTALLED WITH THE APPROPRIATE HARDWARE AND SPACERS IN FORWARD AND AFT HOLES AND TRANSFER DRILL Ø0.50 HOLES FROM SADDLE TO D4095-043

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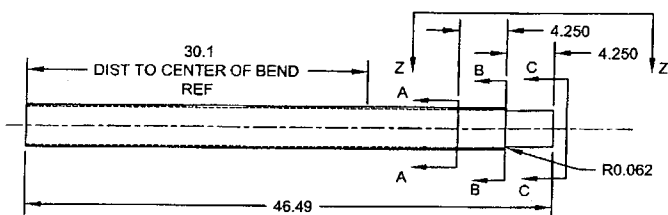
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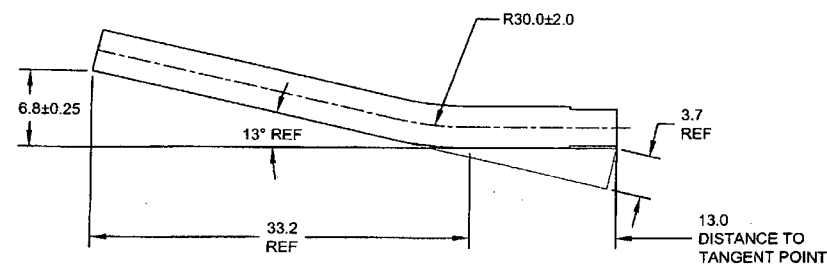
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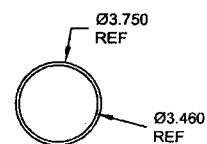
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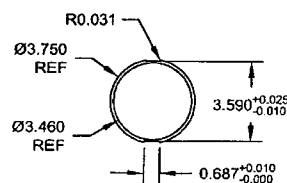
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(MAKE FROM D6013-047 SKIDTUBE MATERIAL)



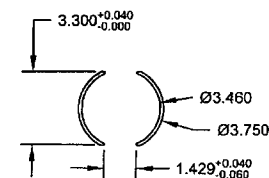
**D3391-011/-021 BENDING DETAIL**  
(MAKE FROM D3391-1)



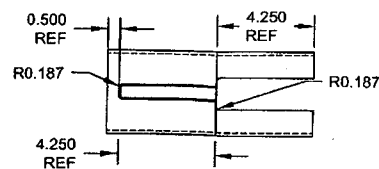
**SECTION A-A**  
SCALE 2X



**SECTION B-B**  
SCALE 2X



**SECTION C-C**  
SCALE 2X



**VIEW Z-Z**  
SCALE 2X

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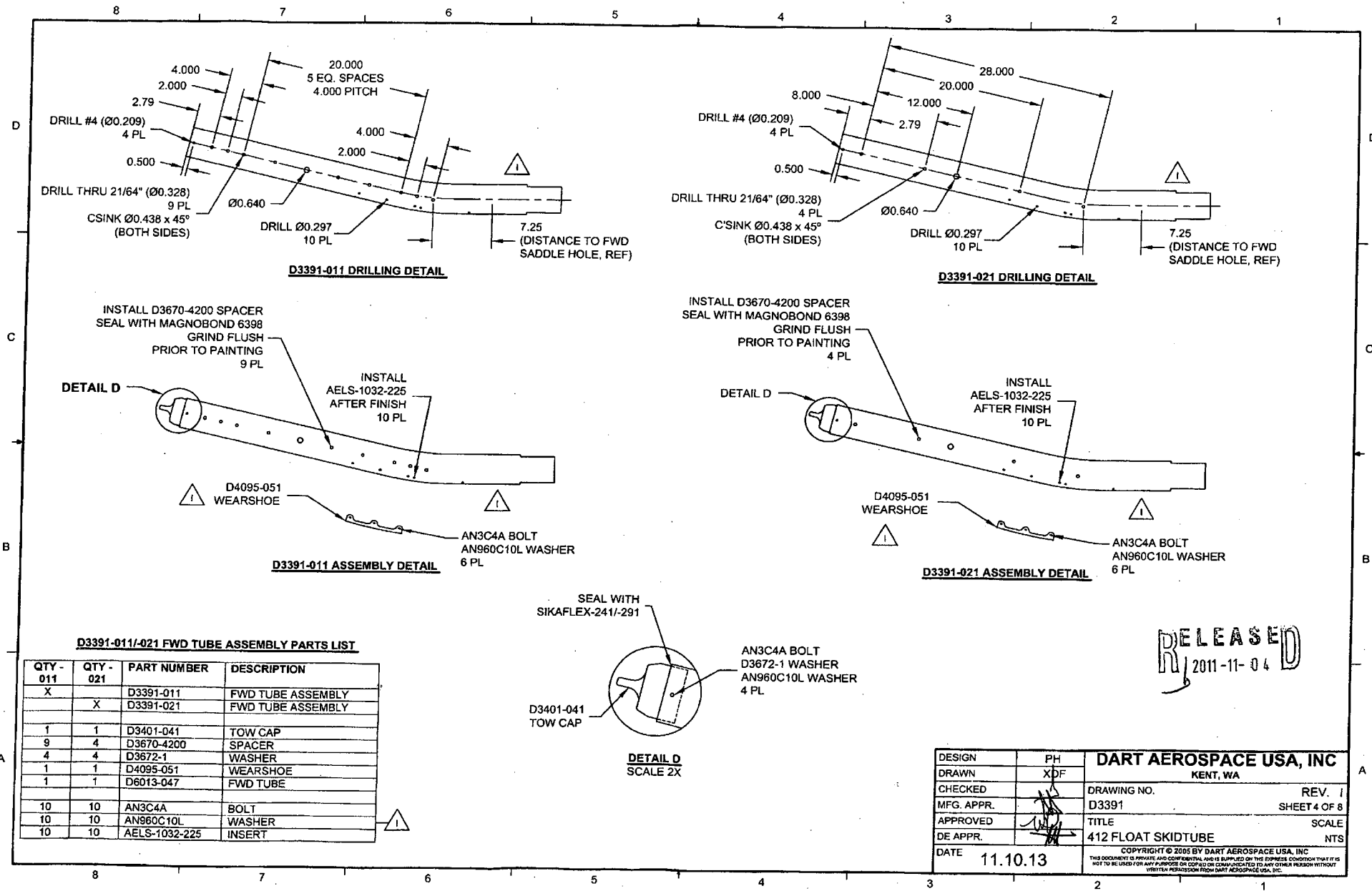
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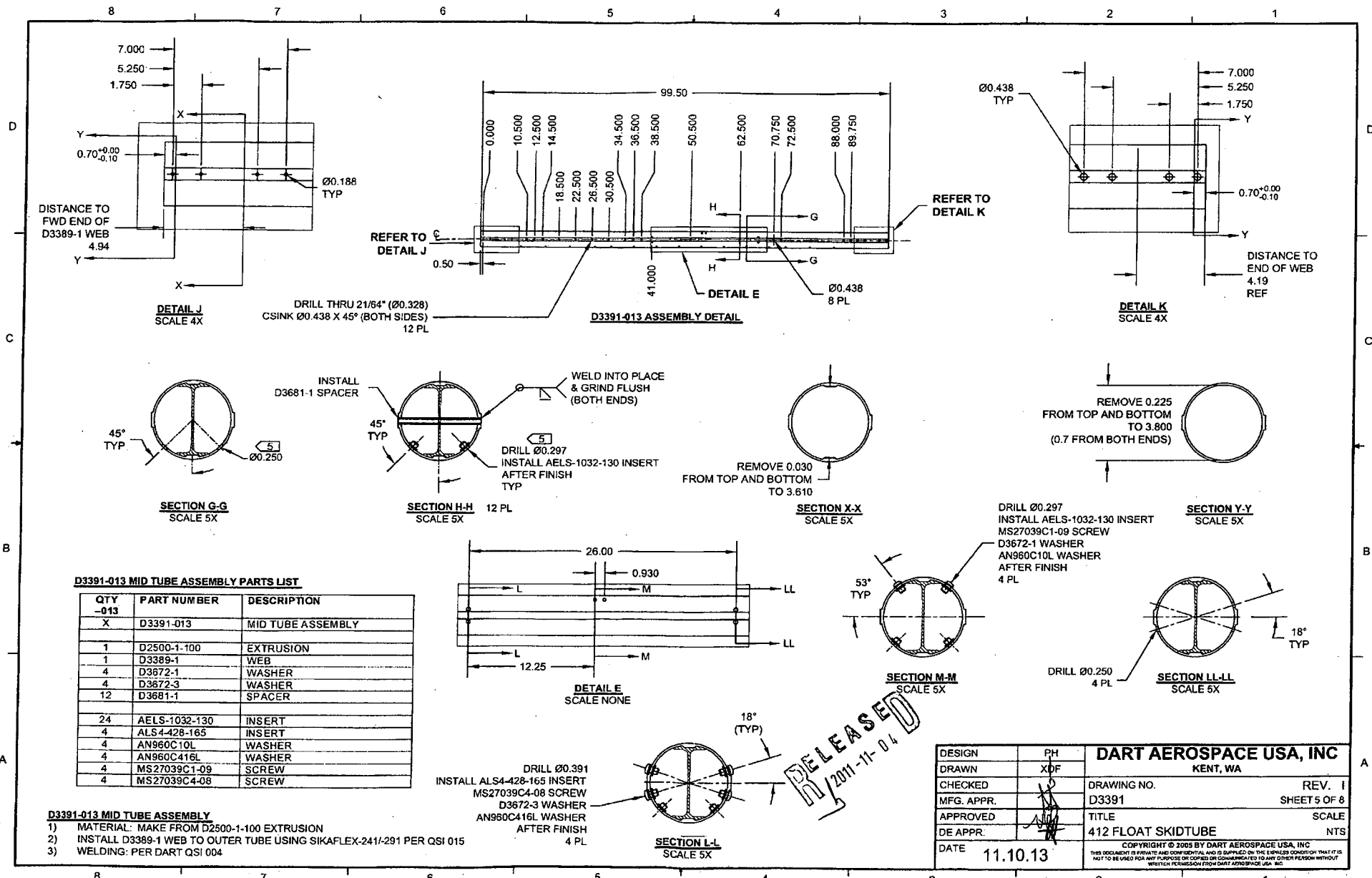
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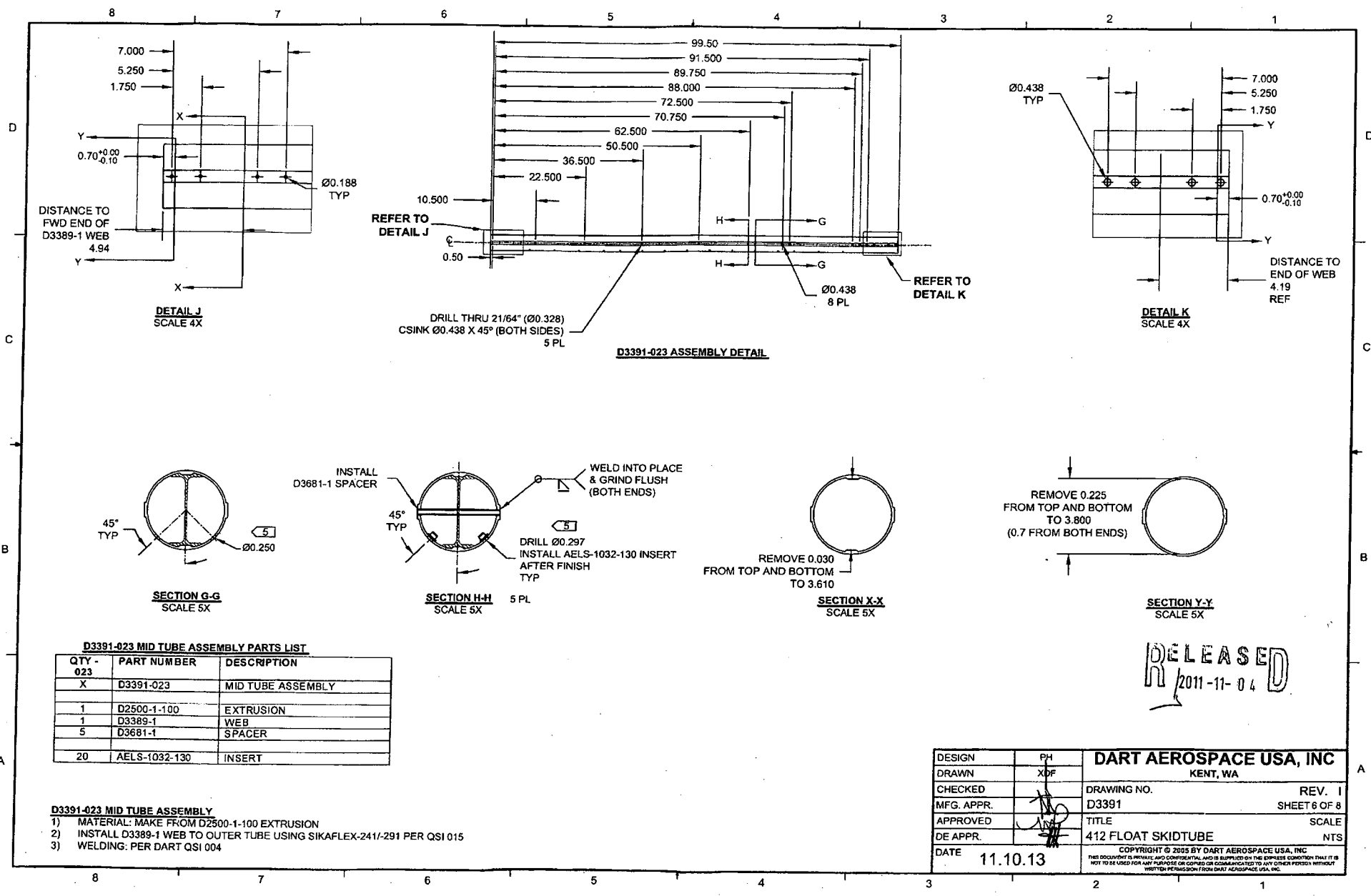
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**Dart Aerospace Ltd**

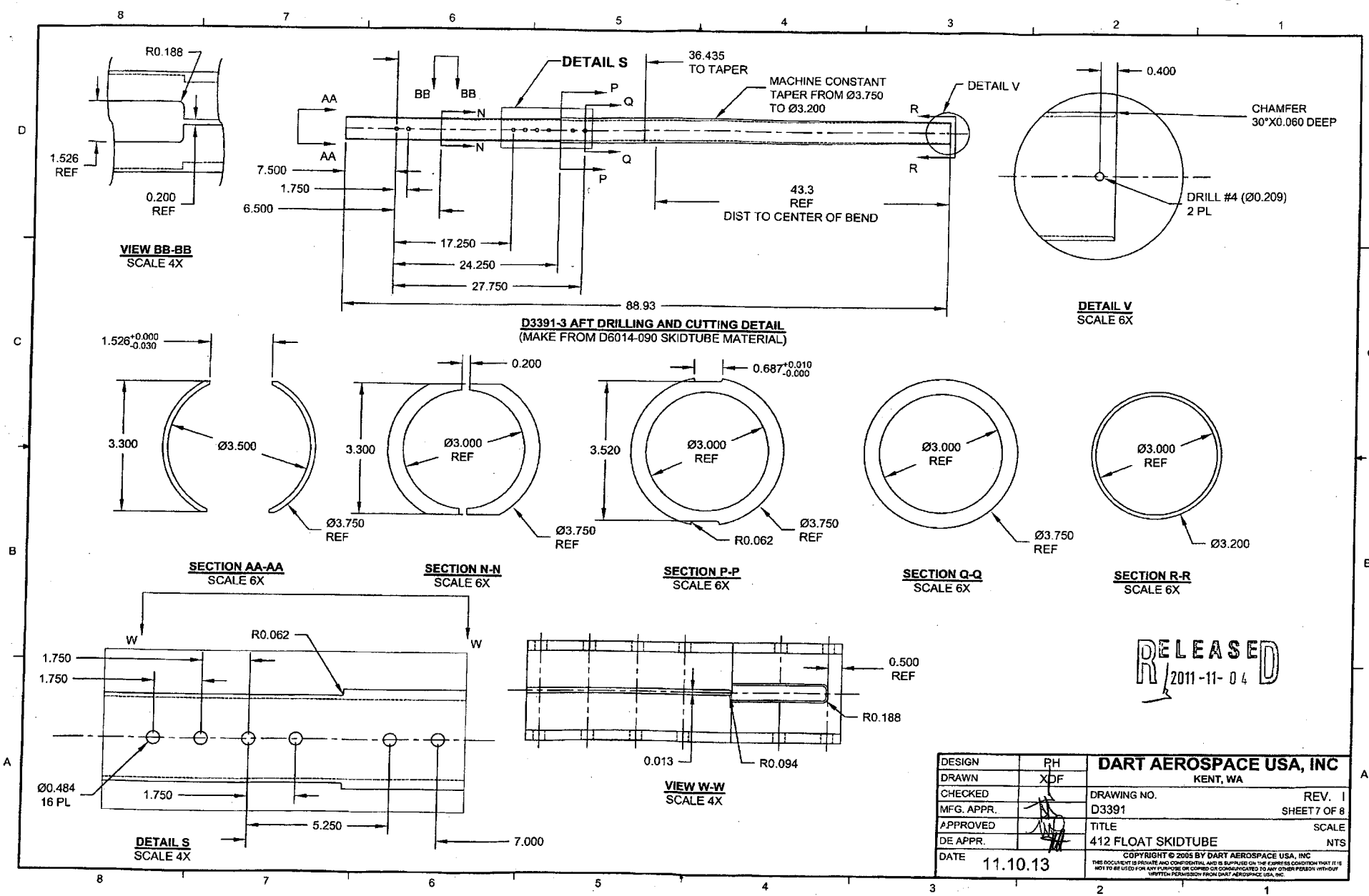
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_



NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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MFG. APPR.		D3391	SHEET 7 OF 8
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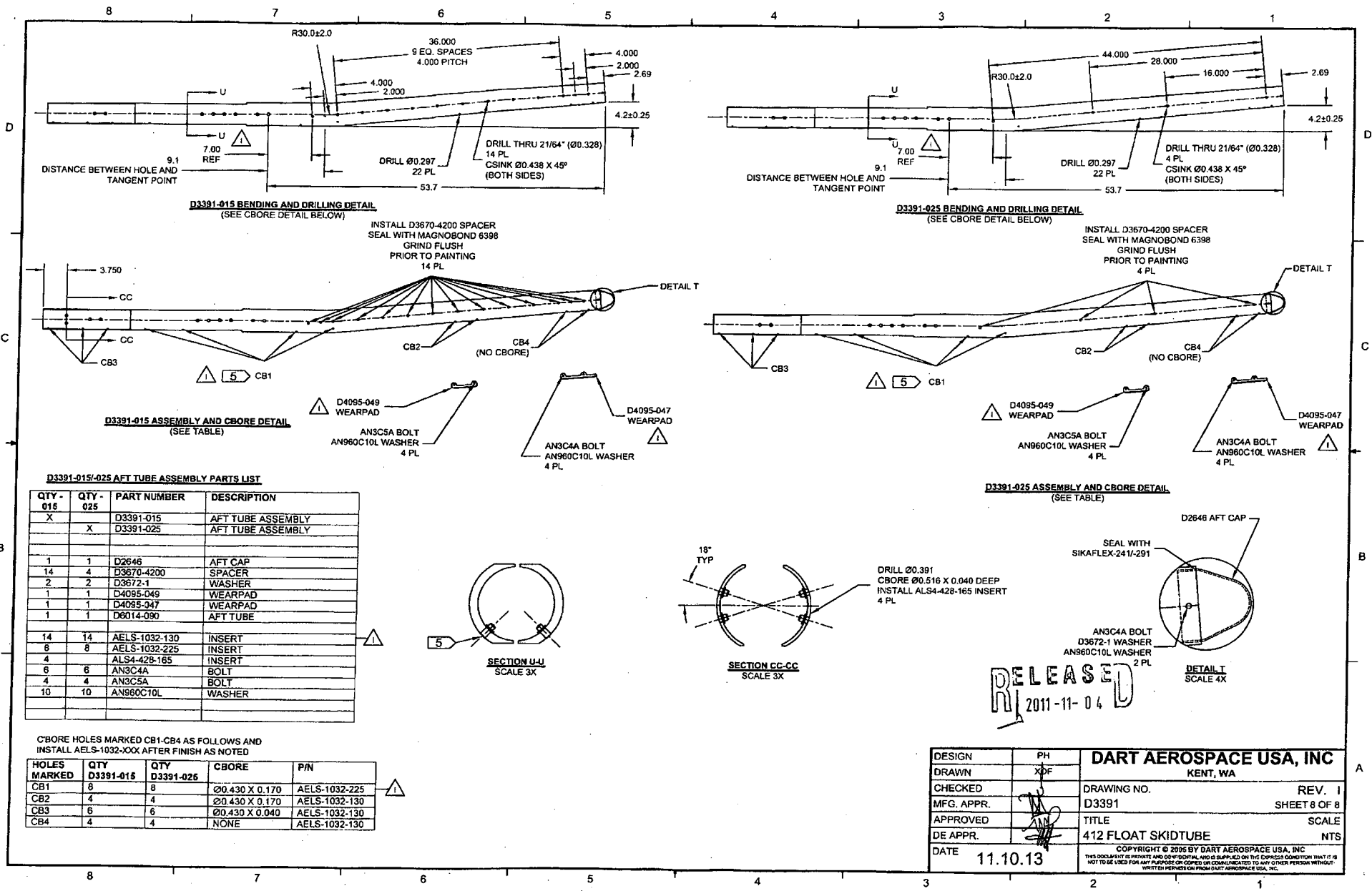
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**NOTE:** Date & initial all entries



20286



D3391-015/-025 AFT TUBE ASSEMBLY PARTS LIST

QTY - 015	QTY - 025	PART NUMBER	DESCRIPTION
X	X	D3391-015	AFT TUBE ASSEMBLY
		D3391-025	AFT TUBE ASSEMBLY
1	1	D2646	AFT CAP
14	4	D3670-4200	SPACER
2	2	D3672-1	WASHER
1	1	D4095-049	WEARPAD
1	1	D4095-047	WEARPAD
1	1	D6014-090	AFT TUBE
14	14	AELS-1032-130	INSERT
8	8	AELS-1032-225	INSERT
4	4	ALS4-428-165	INSERT
6	6	AN3C4A	BOLT
4	4	AN3C5A	BOLT
10	10	AN960C10L	WASHER

CBORE HOLES MARKED CB1-CB4 AS FOLLOWS AND INSTALL AELS-1032-XXX AFTER FINISH AS NOTED

HOLES MARKED	QTY D3391-015	QTY D3391-025	CBORE	P/N
CB1	8	8	Ø0.430 X 0.170	AELS-1032-225
CB2	4	4	Ø0.430 X 0.170	AELS-1032-130
CB3	6	6	Ø0.430 X 0.040	AELS-1032-130
CB4	4	4	NONE	AELS-1032-130

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2011-11-04

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CHECKED				DRAWING NO. REV. 1	
MFG. APPR.				D3391 SHEET 8 OF 8	
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DE APPR.				412 FLOAT SKIDTUBE NTS	
DATE		11.10.13		<small>COPYRIGHT © 2005 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries